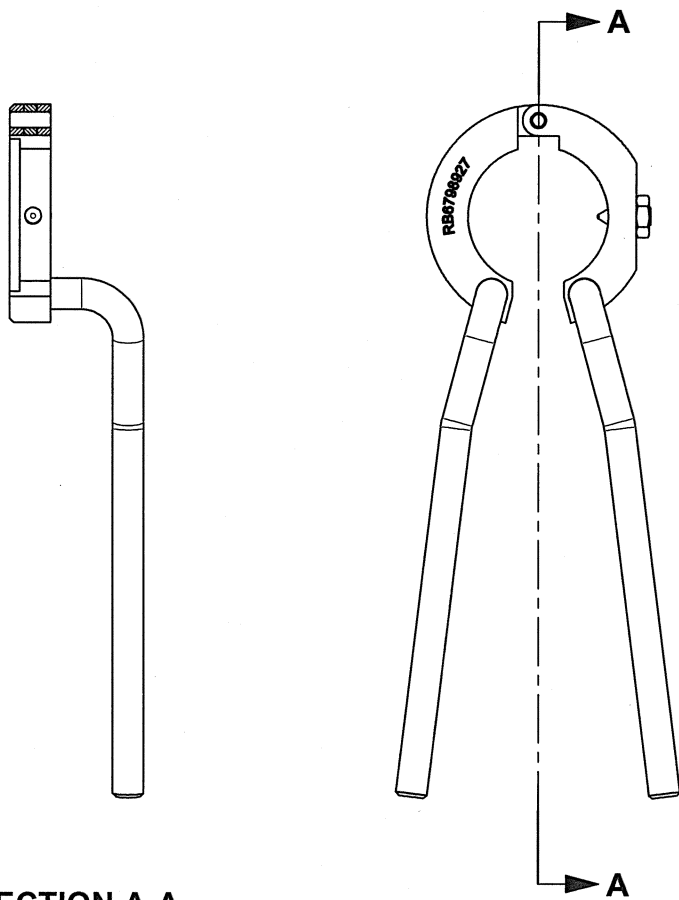


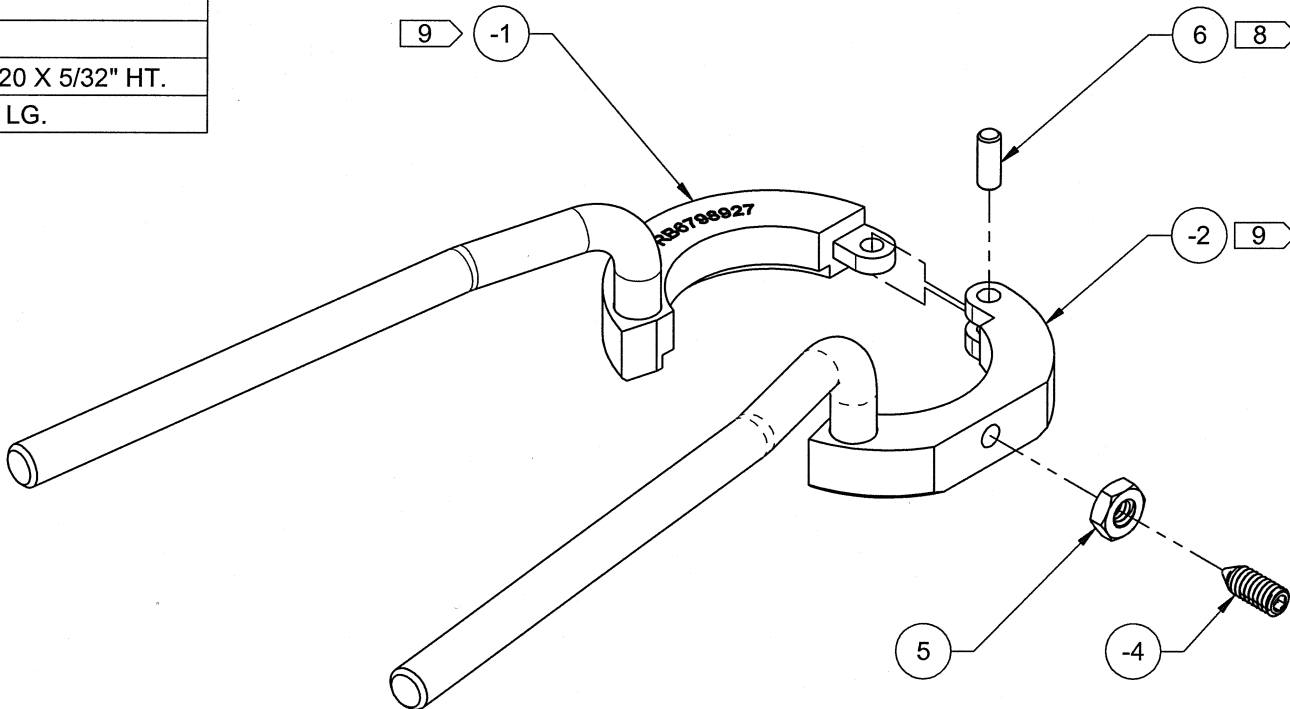
ITEM #	QTY	PART #	PART TITLE
-1	1	RB6798927-1	JAW WELDMENT
-2	1	RB6798927-2	CRIMPER WELDMENT
-4	1	RB6798927-4	CONE POINT SET SCREW
5	1	McMaster#93839A029 OR EQUIV.	GRADE 8 YELLOW ZINC PLATED STEEL THIN HEX NUT 1/4"-20 X 5/32" HT.
6	1	McMaster#98381A314 OR EQUIV.	BLACK OXIDE STEEL DOWEL PIN 3/16" DIA. X 1/2" LG.



SECTION A-A

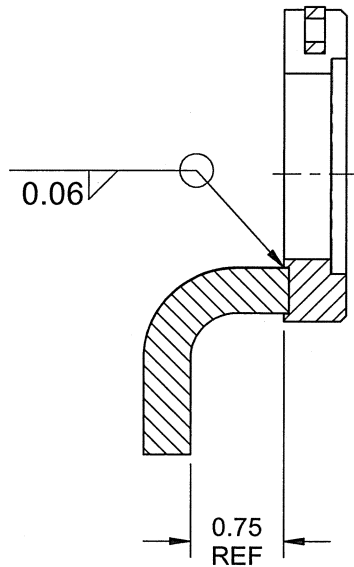
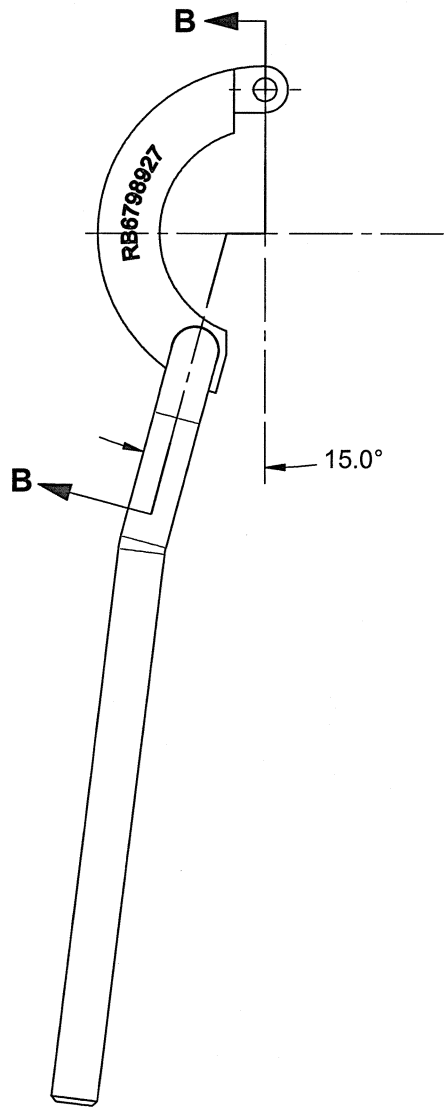
RB6798927 CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 6 WITH ITEM -1, AND REMOVE EXCESS
 - 9) ITEM -1 AND ITEM -2 MUST ROTATE FREELY
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

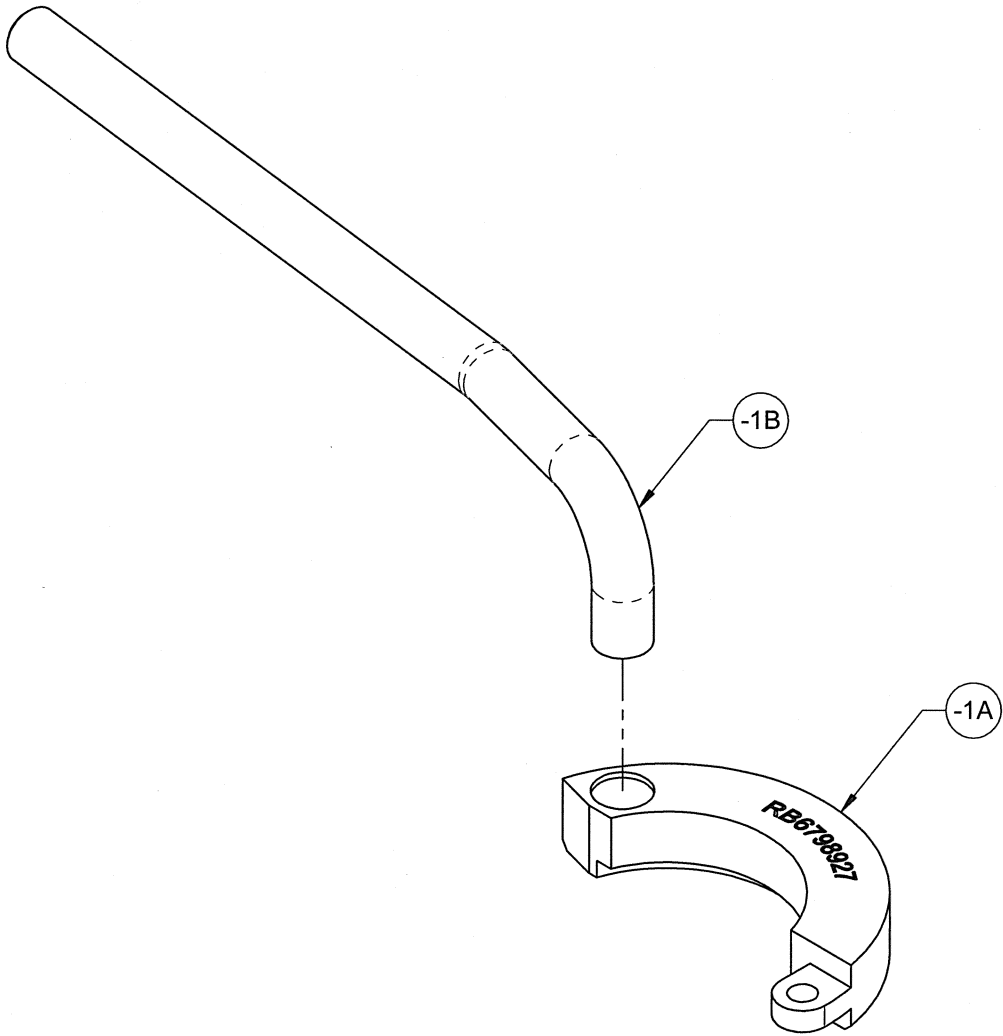


SEE PREVIOUS REVISION FOR MORE INFORMATION		19-752	KPT
UPDATED DRAWING TEMPLATE			
ITEM 5 WAS ITEM -5 MCMASTER-CARR #94846A029 IS McMaster#93839A029			
-1 ITEM NAME WAS JAW IS JAW WELDMENT. DIM WAS 0.75 IS 0.75 REF. REMOVED ENGRAVING NOTE			
-1A ITEM NAME WAS JAW PART IS JAW. DIM WAS Ø.1874-.1867 IS Ø0.1875-0.1867. DIM WAS Ø.385+.020/-0.000 IS Ø0.386. DIM WAS .170±.005 IS 0.180-0.175. REMOVED .56 DIM. ADDED R0.008 MAX DIM. ADDED ENGRAVING NOTE			
-1B ITEM NAME WAS JAW PART IS JAW HANDLE. REMOVED Ø.375+.005/-0.020 AND .060 DIMS. ADDED R0.38 DIM AND FLAT PATTERN			
-2 ITEM NAME WAS CRIMPER JAW IS CRIMPER WELDMENT			
-2A ITEM NAME WAS JAW PART IS CRIMPER. DIM WAS Ø.385+.020/-0.000 IS Ø0.386. DIM WAS Ø.1902-.1890 IS Ø0.1890. REMOVED .56 DIM. ADDED R0.008 MAX DIM			
-2B ITEM NAME WAS JAW PART IS CRIMPER HANDLE. REMOVED Ø.375+.005/-0.020 AND .060 DIMS. ADDED R0.38 DIM AND FLAT PATTERN			
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV C
MFG. APPR.	FK	RB6798927	SHEET 1 OF 8
APPROVED	Wp	TITLE	SCALE
		CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	NTS
DATE	2019-07-04	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-1A	1	RB6798927-1A	JAW
-1B	1	RB6798927-1B	JAW HANDLE



SECTION B-B



RB6798927-1 JAW WELDMENT

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV C
MFG. APPR.	FK	RB6798927	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DATE 2019-07-04		CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	NTS
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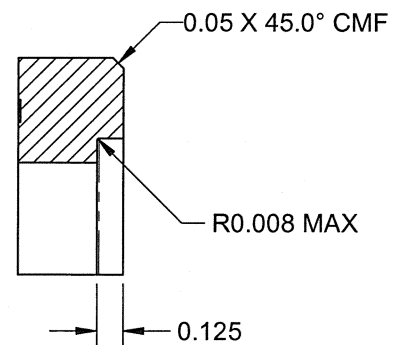
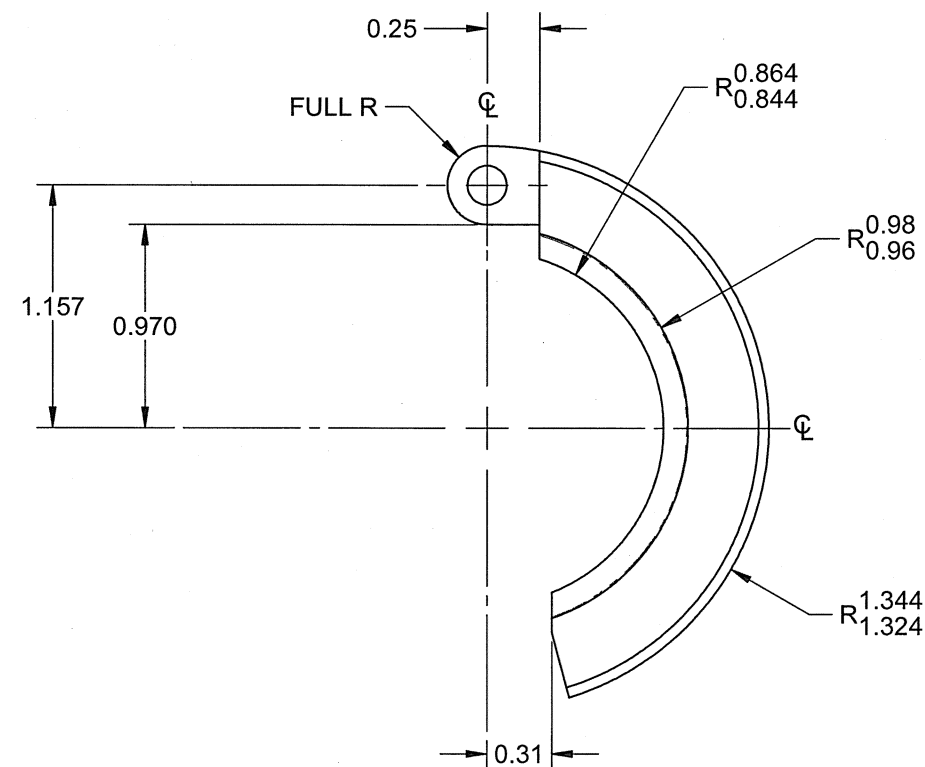
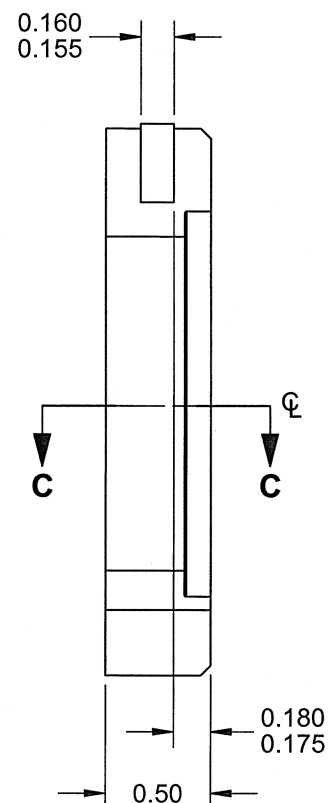
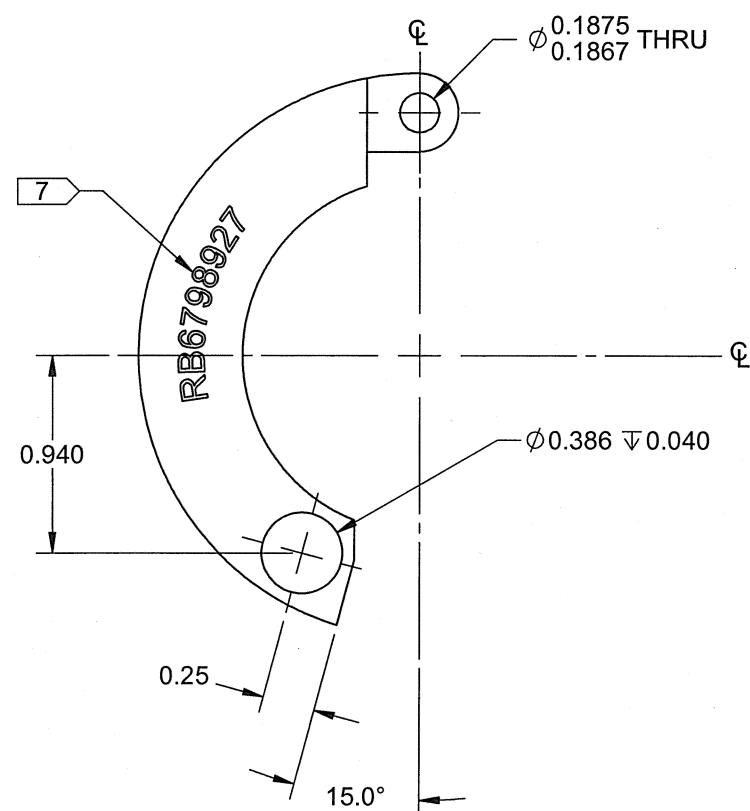
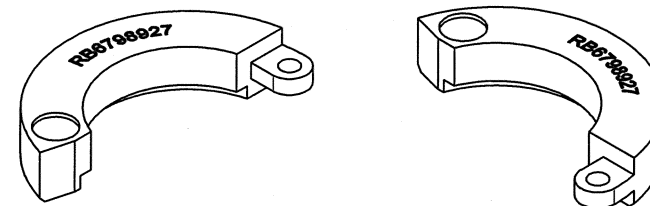
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**SECTION C-C****RB6798927-1A JAW****NOTES:**

- 1) MATERIAL: 4140
2) HEAT TREAT: 32-36 RC
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6798927", AS SHOWN

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB6798927-1A REV C.STEP

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV C
MFG. APPR.	FK	RB6798927	SHEET 3 OF 8
APPROVED		TITLE	SCALE
		CRIMPER-LOCK NUT COMPRESSOR	NTS
		IMPELLER ASSY AND TURBINE POWER SHAFT	
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DATE	2019-07-04		

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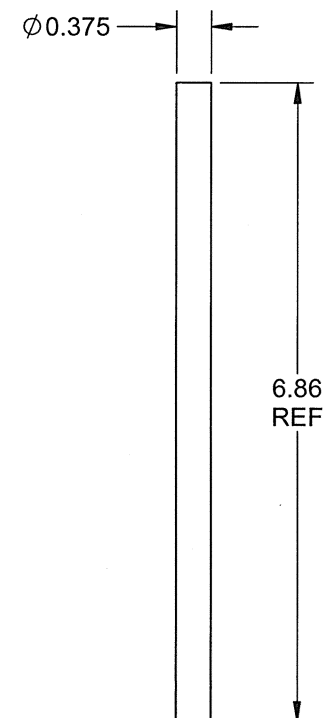
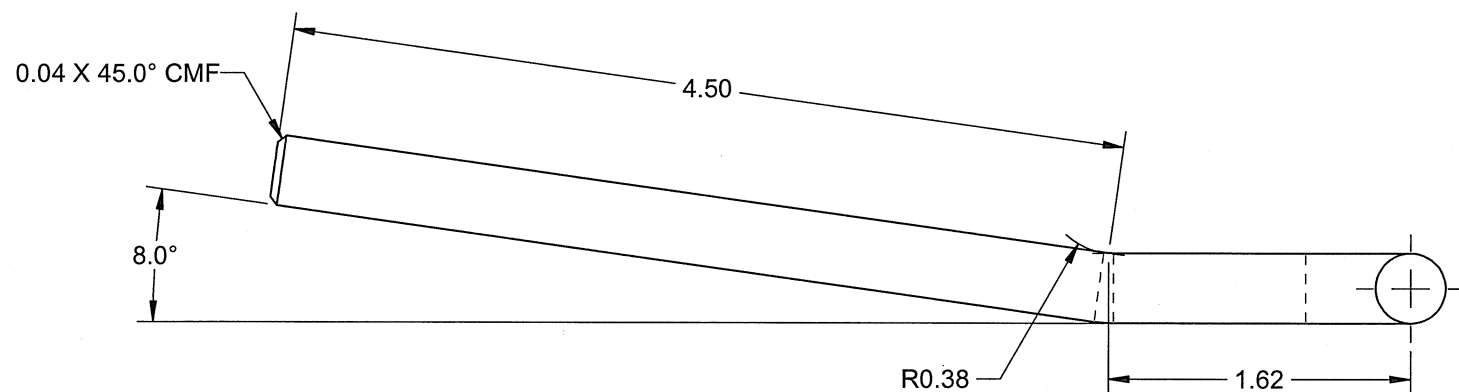
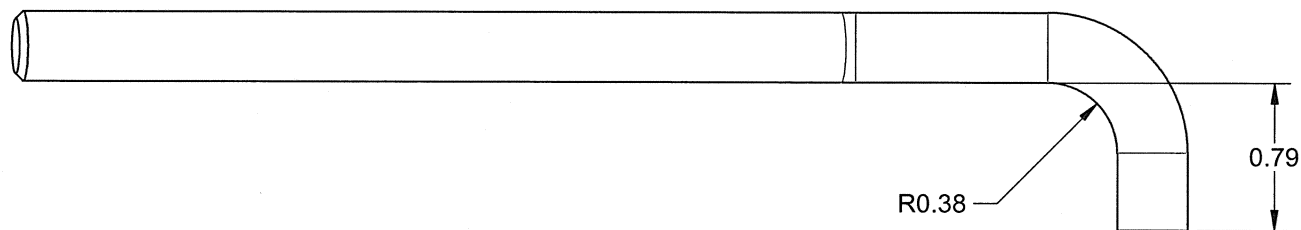
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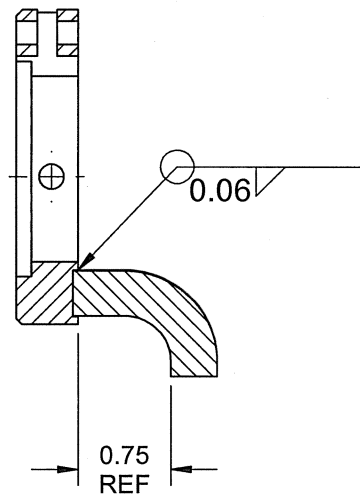
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**FLAT PATTERN****RB6798927-1B JAW HANDLE****NOTES:**

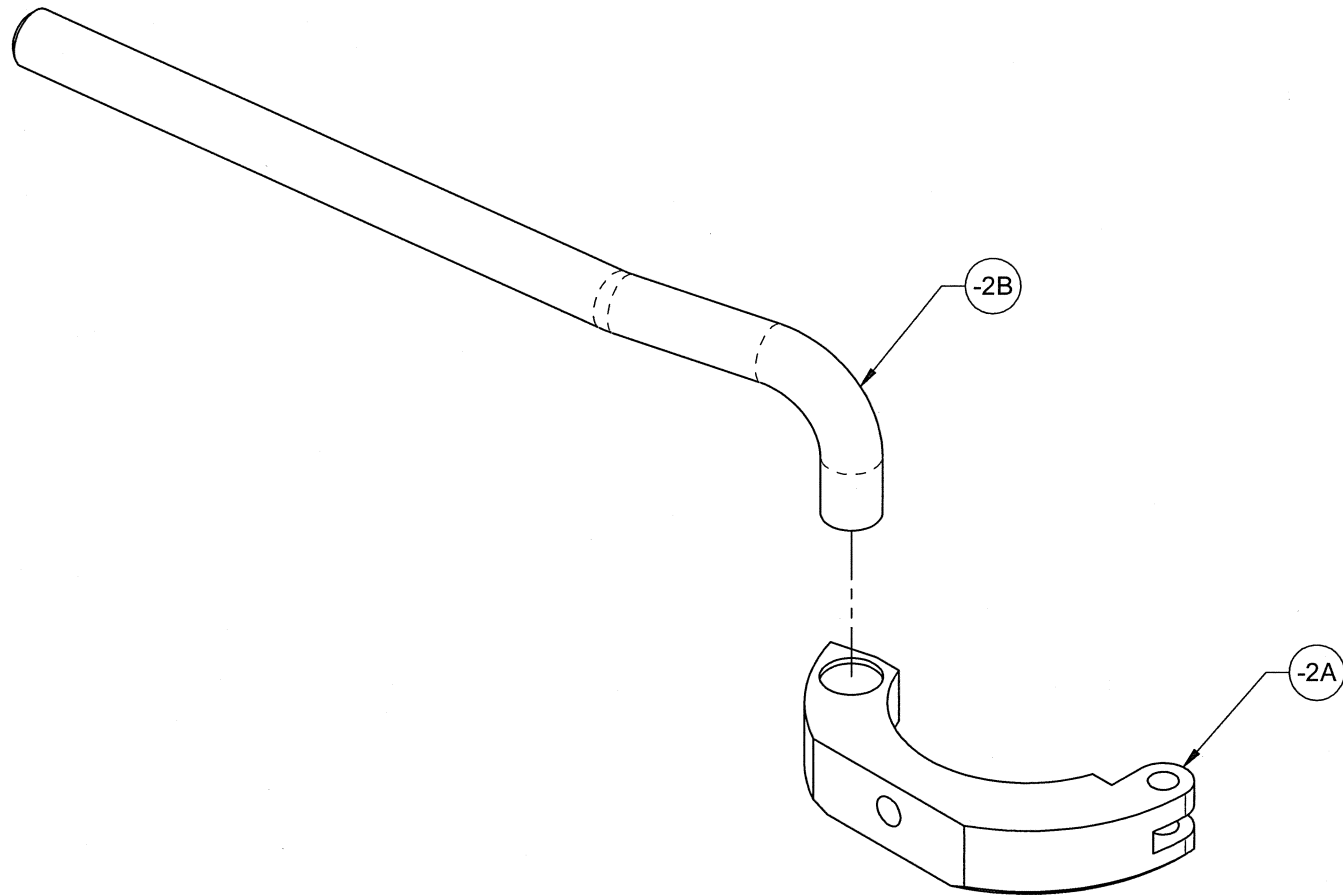
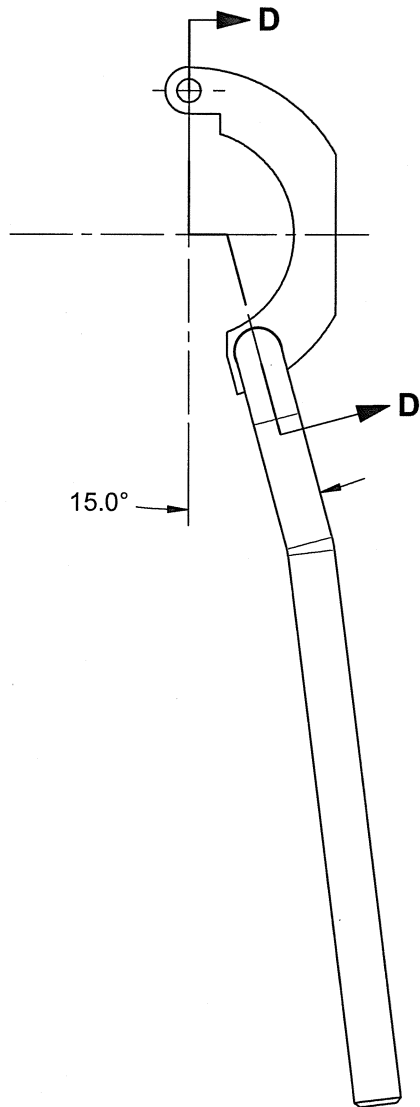
- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV C
MFG. APPR.	FK	RB6798927	SHEET 4 OF 8
APPROVED		TITLE	SCALE
		CRIMPER-LOCK NUT COMPRESSOR	NTS
		IMPELLER ASSY AND TURBINE POWER SHAFT	
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DATE	2019-07-04		

ITEM #	QTY	PART #	PART TITLE
-2A	1	RB6798927-2A	CRIMPER
-2B	1	RB6798927-2B	CRIMPER HANDLE



SECTION D-D



RB6798927-2 CRIMPER WELDMENT

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART # RB6798927	REV C
MFG. APPR.	FK	TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	SHEET 5 OF 8
APPROVED		SCALE NTS	
DATE	2019-07-04	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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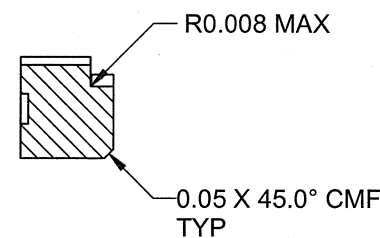
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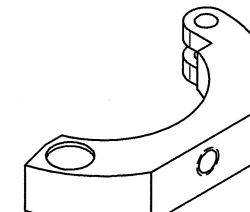
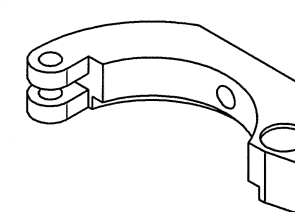
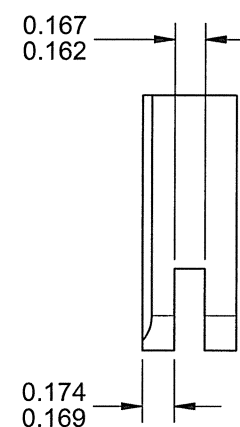
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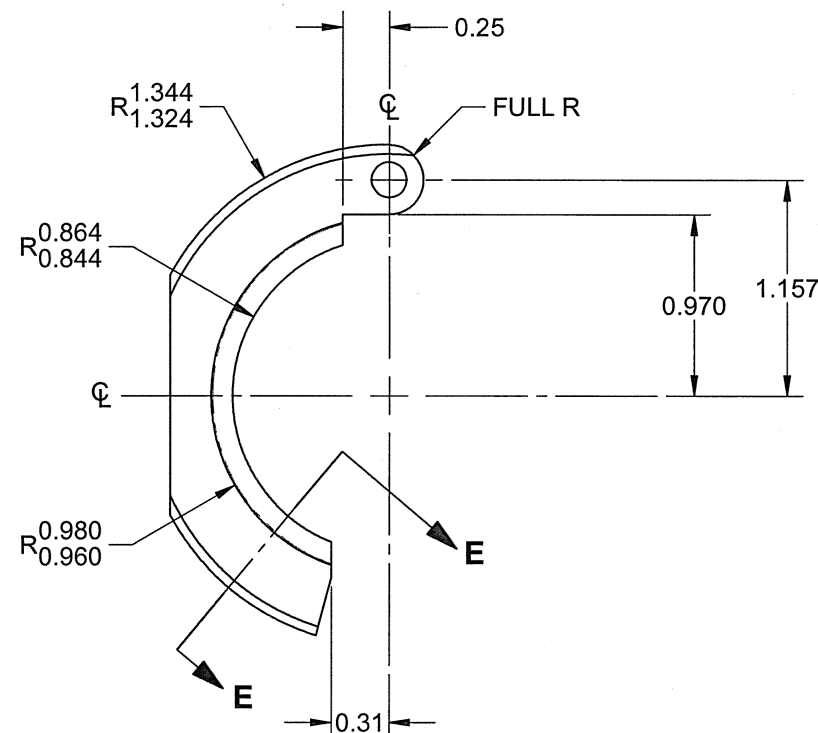


SECTION E-E
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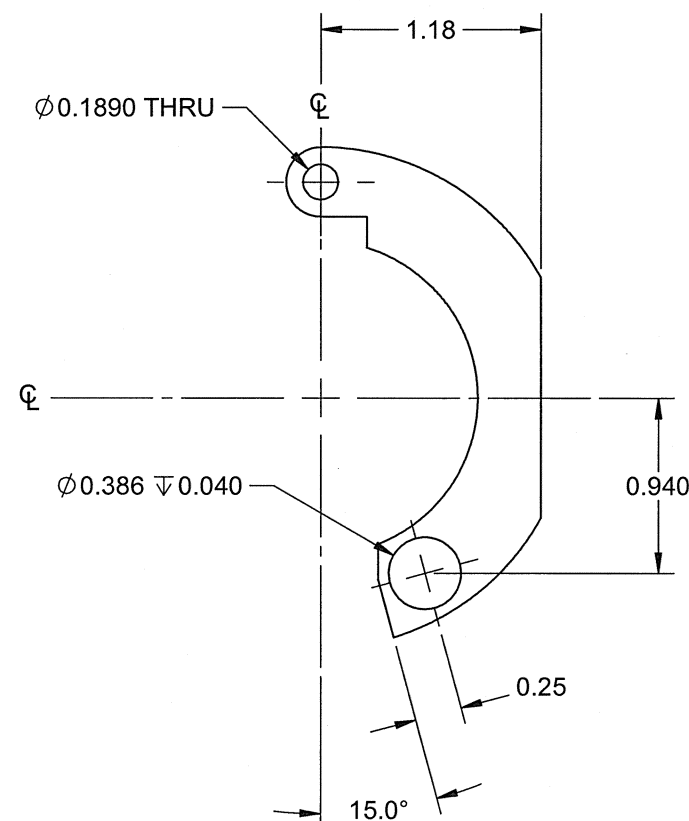
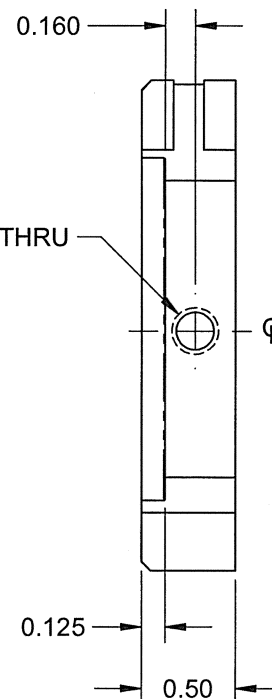


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1/4-20 UNC THRU



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RB6798927-2A CRIMPER

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NOTES:

- 1) MATERIAL: 4140
2) HEAT TREAT: 32-36 RC
3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) REMOVE ALL SHARP EDGES AND BURRS

- 7) IDENTIFICATION: N/A

- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB6798927-2A REV. REV C.STEP

A

A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV C
MFG. APPR.	FK	RB6798927	SHEET 6 OF 8
APPROVED		TITLE	SCALE
		CRIMPER-LOCK NUT COMPRESSOR	NTS
		IMPELLER ASSY AND TURBINE POWER SHAFT	
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DATE	2019-07-04		

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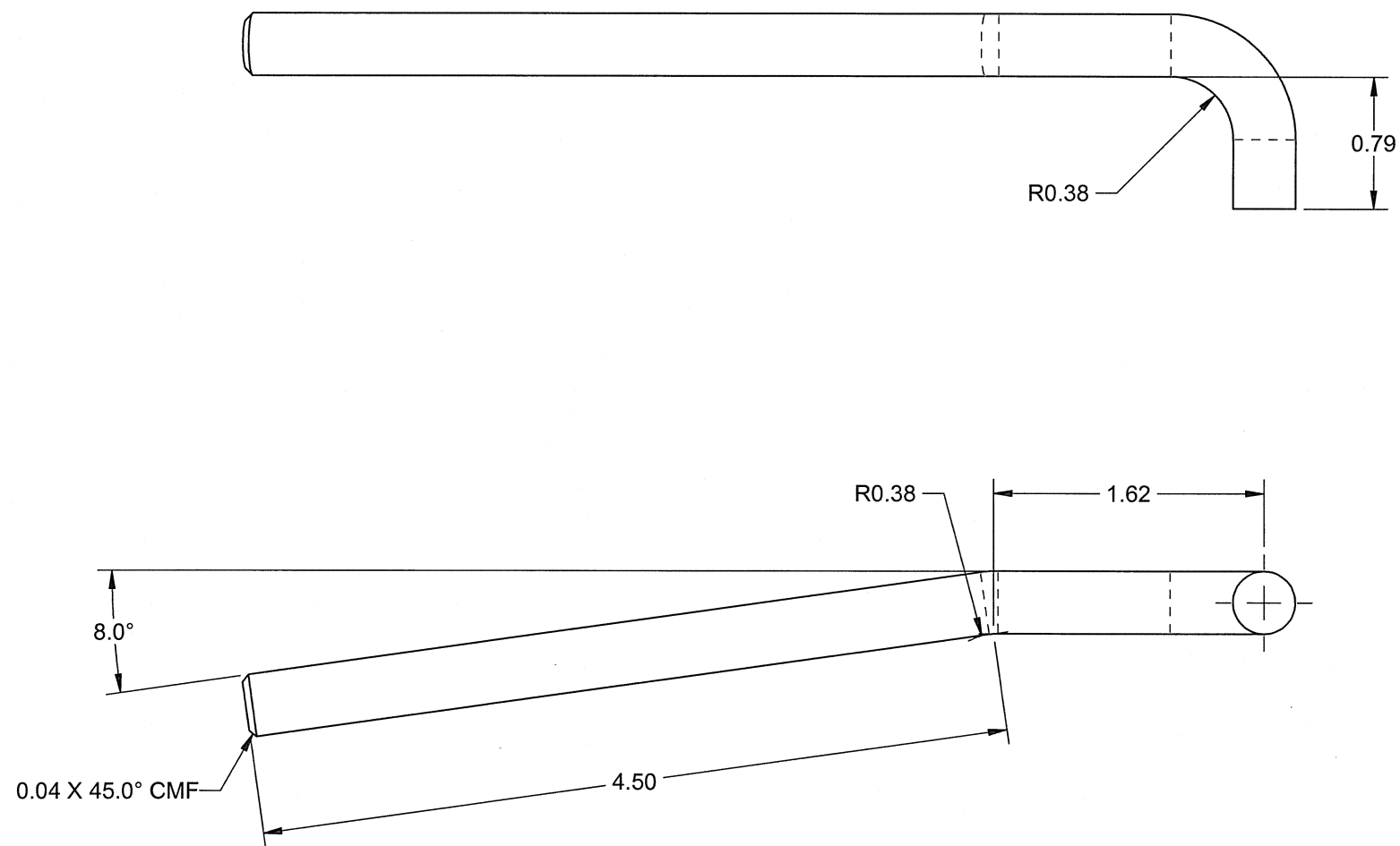
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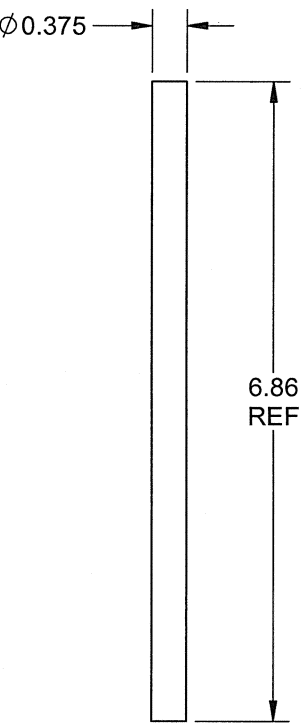
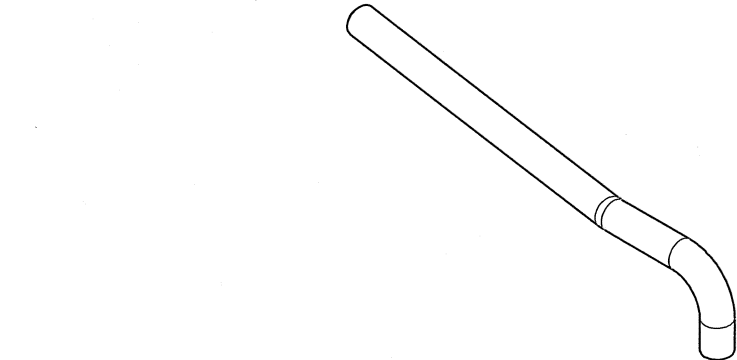
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RB6798927-2B CRIMPER HANDLE



FLAT PATTERN

NOTES:
1) MATERIAL: 4140 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV C
MFG. APPR.	FK	RB6798927	SHEET 7 OF 8
APPROVED		TITLE	SCALE
		CRIMPER-LOCK NUT COMPRESSOR	NTS
		IMPELLER ASSY AND TURBINE POWER SHAFT	
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DATE	2019-07-04		

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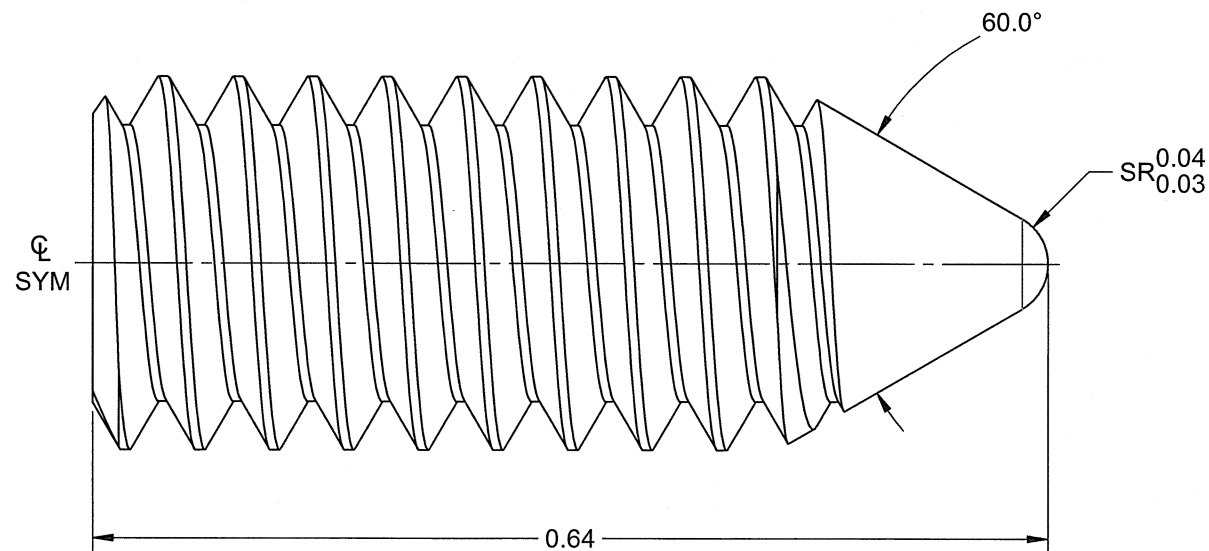
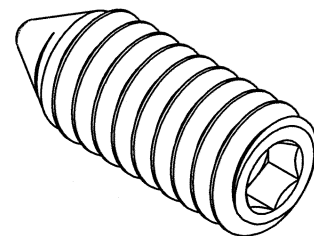
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RB6798927-4 CONE POINT SET SCREW

NOTES:

1) MATERIAL: McMaster#92695A307 OR EQUIV. (STEEL CONE POINT SET SCREW 1/4"-20 X 3/4" LG.)

2) HEAT TREAT: N/A

3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°



X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART # RB6798927	REV C
MFG. APPR.	FK	TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	SHEET 8 OF 8
APPROVED		SCALE NTS	
DATE	2019-07-04	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	